

Work Order ID 58340

Monday, May 03, 2010 2:55:47 PM



Page 1

Item ID: D3909-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Lower Attach Arm

Stop



Start Date: 5/3/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 5/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: YMFDate: 10-5-3 Tooling:

Date:

Run Start



QC:

Date: _____ SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

D3909 B

100 Cut blanks as per folio

0.00



Bandsaw

Memo

0.00 ank 10/6/0812 0

Jeaspa Bandsaw

CUT BLANK 3.455" LONG

110



HAAS I

HAAS CNC vertical machine #1

Memo

0.00

12 0MACHINE AS PER FOLIO FA872 AND DWG
FOLIO REV: AA
DWG REV: Bank 10/6/10

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan:

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

2010/05/10

12 8

0.00

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

MJ= 10/05/10

12 8

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location: 094

0.00

Memo

0.00

P105 11 12

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Required Date: 5/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/05/12 JJ

Memo

0.00

10-5-4

(12)

W/O:		WORK ORDER CHANGES						
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Picklist Print

Monday, May 03, 2010 2:55:46 PM

Page 1

Work Order ID: 58340



Parent Item: D3909-3



Parent Item Name: Fwd Lower Attach Arm

Start Date: 5/3/2010

Required Date: 5/12/2010

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP
Rev:B chg blank size in seq 100 DD 10.02.10 verified JLM IPP Rev:C as per
dwg revB DD 10.04.20 verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ M303B0.750X1.500	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of f	Qty on 6.0949	Qty per Kit 0.3333	Qty	Date	Status
303 BAR .750" X 1.500"												

303 BAR .750" X 1.500"

Location	Loc Qty	Loc Code
MAT53	6.0949	
113310	6.0949	

4.195 5/3/10/05/10

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DART AEROSPACE LTD	Work Order:	58340
Description: Fwd Lower Attach Arm	Part Number:	D3909-3
Inspection Dwg: D3909 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>ML</u>	Audited by:	<u>MJG</u>	Preliminary Approval:	
Date:	10/05/09	Date:	10/05/09	Date:	

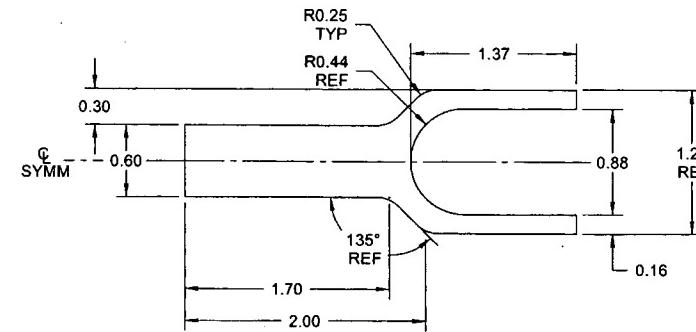
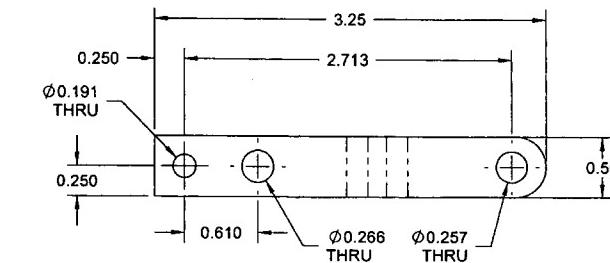
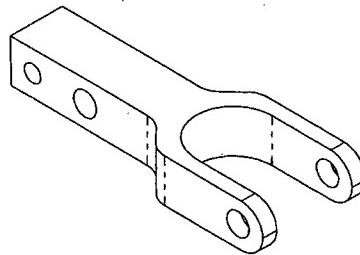
Rev	Date	Change	Revised by	Approved
A	10.04.20	New Issue	KJ	 

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D3909-3 FWD LOWER ATTACH ARM

RELEASED
2010-04-07
[Handwritten Signature]

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D3909	REV. B
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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